

Date: Wednesday, 15/11/2006 7:48:36 AM
 User: Linda Lacelle









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 SKIDTUBE "I" BEAM
Job Number : 29455	
Estimate Number : 10346	
P.O. Number : <i>N/A</i>	Part Number : D2596
This Issue : 15/11/2006 S.O. No. : <i>Sit</i>	Drawing Number : D2596 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : C
Previous Run : 28652	Material : <i>N/A</i>
Written By : _____	Due Date : 22/11/2006 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost M D	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D25003100	Ext'n -I' Beam Web 4"								
 										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion "I" Beam Web 4" Pick; <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2500-3-100</td> <td>Extrusion</td> <td>B25751</td> </tr> </table> <i>m-h 06/11/15</i> (20)			Qty	Part Number	Description	Batch	1	D2500-3-100	Extrusion	B25751
Qty	Part Number	Description	Batch							
1	D2500-3-100	Extrusion	B25751							
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1								
 										
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" <i>m-h 06/11/15</i> (20) 2- Use Jig DT8093 to drill pilot holes #30 <i>m-h 06/11/15</i> (20) 3- Open to 0.625" diameter using a uni-bit <i>m-h 06/11/15</i> (20) 4- Deburr <i>m-h 06/11/15</i> (20) <i>06/11/16</i> (20)										
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1								
 										
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 <i>m-h 06/11/16</i> (20)										
4.0	QC5	INSPECT WORK TO CURRENT STEP								
 										
Comment: INSPECT WORK TO CURRENT STEP <i>DP 6-11-20</i> (20)										

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *12* Date: 06/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 29455

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 6-11-20

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20
R 06/11/20

Job Completion



u 06.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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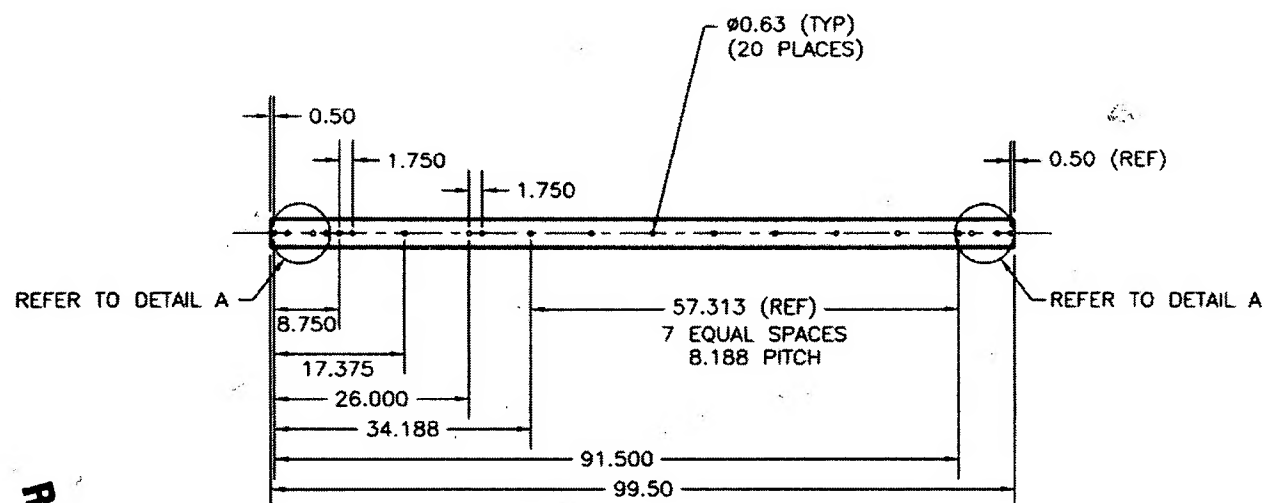
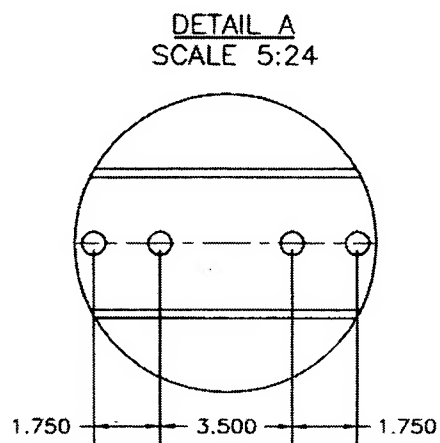
NOTE: Date & initial all entries

DART



RELEASED
98.09.17 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE		TITLE	SHEET 1 OF 1	SCALE
98.09.14		205 WEB		1:24
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY